

Work Order ID 78463

January-10-12 9:48:45 AM

78463

Page 1

Item ID: D206-667-107BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| D206-667-147 | A (DEO) |
| DSI9565 | A |
| IIN-D206-667 | D |

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-107 chg 002

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

Pto →

12-01-25 (1)
MLJ 12-1-25

MO

12/1/11

| W/O: 78463 Perm. Change | | WORK ORDER CHANGES | | | | | |
|-------------------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 12/14/14 | #100 | up Date FAZ sheet | | | | | S 12/14/14 |
| | | | | | | | |

Part No: D206667-107BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78463

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

Reference:

Run Start *NR1*

Stop ***NR2***

XL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78463

78463

Page 3

January-10-12 9:48:45 AM

Item ID: D206-667-107BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Mid Fwd, Blue
Start Date: 10/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 25/01/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | Crosstubes | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Crosstubes | Memo | 0.00 | | | | | | | |
| Crosstubes | 1-Drill holes & ream using drill Jig DT & DT as per Dwg D206-667-147. Drill all (3) top holes. | | | | | | | | |
| | 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. | | | | | | | | |
| | 4-Drill pilot holes using drill Jig DT & DT as per Dwg D206-667-147. Drill only the top (2) holes. | | | | | | | | |
| | 5-Drill pilot holes as per Dwg D206-667-147. Drill only the top (2) holes. | | | | | | | | |
| | 6-Drill Fwd rivet holes using drill Jig DT as per Dwg D206-667-147. Note: Fwd side has 3x top holes. | | | | | | | | |
| | 7-Drill Aft rivet holes using drill Jig DT as per Dwg D206-667-147. | | | | | | | | |
| | 8-C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. | | | | | | | | |
| | 9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-147 Inside of Cuff(Donot engrave on outside of tube) | | | | | | | | |
| | 10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-147 | | | | | | | | |

JW
MO

12-1-12

MO 12/1/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

78463

Page 4

N900040100

Setup Start *NS1*

Stop ***NS2***

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

0.00

MO

12/1/12

0.00

0.00

8/12/17

0.00

0.00

Sinhala

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78463

78463

Page 5

January-10-12 9:48:45 AM

Item ID: D206-667-107BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Mid Fwd, Blue
 Start Date: 10/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | Outsource process - NDT per QSI038 4.1 | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Outsource2 | Memo | 0.00 | | | | | | | |
| Outsource process - NDT | CROSSTUBES | | | | | | | | |
| | | | | | | | | | |
| 190 | | 0.00 | | | | | | | |
| *190* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Ensure copy of NDT results attached to work order. | | | | | | | | |
| | | | | | | | | | |
| 200 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

1554e PO 15920

LPI 95 per

R1201-18

ASTM 1417 Level 2

6/26/18

5/2/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 78463

78463

Page 6

January-10-12 9:48:45 AM

Item ID: D206-667-107BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Mid Fwd, Blue
 Start Date: 10/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210 | SprayPaint | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| SprayPaint | Memo | 0.00 | | | | | | | |
| Spray Painting | 1-Prime inside and outside crosstube as per QSI 005 4.2 | | | | | | | | |
| | 2-Paint outside crosstube with White Imron as per QSI 005 4.2 | | | | | | | | |
| | PRIME: | | | | | | | | |
| | Start Time: 6:00 | | | | | | | | |
| | Finish Time: 7:00 | | | | | | | | |
| | PAINT: | | | | | | | | |
| | Start Time: 11:00 | | | | | | | | |
| | Finish Time: 12:00 | | | | | | | | |
| 220 | QC14- Inspect Spray Paint | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | Wrap in plastic bag to protect from scratches | | | | | | | | |

25 12-01-19

M 12-01-23(1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78463***78463***

Page 7

January-10-12 9:48:45 AM

Item ID: D206-667-107BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9565 and QSI 015

A/R Proseal 890 Batch: 120072

AS/AS 12-01-23

3- Torque bolts as per dwg

4-Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron
paint. AS 12-1-24

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

8/12/12/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 78463***78463***

Page 8

January-10-12 9:48:45 AM

Item ID: D206-667-107BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

270

Packaging

0.00

270

Packaging

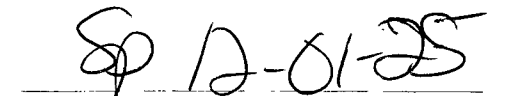
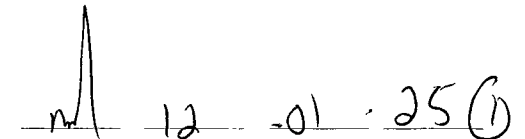
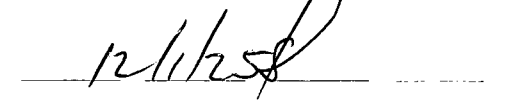
Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-107

Location: _____

PPP Rev: A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 78463***78463***

Page 9

January-10-12 9:48:45 AM

Item ID: D206-667-107BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/1/25 [Signature]
ME
12-01-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

January-10-12 9:48:52 AM

Page 1

Work Order ID: 78463

78463

Parent Item: D206-667-107BL

***D206-667-107RI ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: revA 11.01.13 New Issue EC verified by:DD
11.08.08 PER ECN 11-615 DD VERF:EC

IPP REV:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D206-667-147TRN

Manufactured

No

110

Each

2.0000

1

1

D206-667-147TRN

**

Crosstube Assembly, Mid Fwd

Location

Loc Qty

Loc Code

LG

69976

69980

2

1

1

230

Each

34.0000

2

2

D2873-043

Manufactured

No

D2873-043

**

Nut Plate Assembly

Location

Loc Qty

Loc Code

LG052

72644

73605

75010

34

2

12

20

230

Each

27.0000

2

2

D2873-045

Manufactured

No

D2873-045

**

Nut Plate Assembly

Location

Loc Qty

Loc Code

LG052

73529

74985

27

7

20

2

As 12-1-24

—Pto

Dart Aerospace Ltd

| W/O: 78463 | | WORK ORDER CHANGES | | | | | |
|------------|------|--|----|---------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 12.01.23 | 230 | MS21920-20 M119386 Page #3 missing in w/o | Ag | 12-1-24 | 4 | | S 12/01/25 |
| | | | | | | | |

Part No: D206-667-107BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

January-10-12 9:48:52 AM

Work Order ID: 78463

78463

Parent Item: D206-667-107BL

***D206-667-107BL ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2891-1 Manufactured No

230

Each

40.0000

2

2

D2891-1

2.25 Support

Location

Loc Qty

Loc Code

LG052

40

72822

20

75176

20

2

Ad 12-01-23

D3595-063-395 Manufactured No

230

Each

98.0000

4

4

D3595-063-395

RUBBER CUSHION

Location

Loc Qty

Loc Code

MAT052

98

70975

21

74300

77

4

Ad 12-01-23

cut (4)0.063" X 3.95"

MS20601-AD4W8

Purchased

No

230

Each

321.0000

14

14

MS20601-AD4W8

RIVET

Location

Loc Qty

Loc Code

LG

100

108521

100

LG051

121

117106

7

117381

3

117979

3

118572

8

119107

100

ST322

100

118454

100

8

Ad 12-01-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 4

January-10-12 9:48:52 AM

Work Order ID: 78463

78463

Parent Item: D206-667-107BL

***D206-667-107BI ***

Parent Item Name: Crosstube Mid Fwd, Blue

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-7A Purchased No

250 Each 2,821.000 10 10

AN5-7A

Bolt

**

Location

Loc Qty

Loc Code

ST337

2821

117313

6

118422

1

119017

2814

AN960JD516 NAS1149D0563J Purchased No

250 Each 0.0000 18 18

AN960JD516

Washer

**

AN970-4 Purchased No

250 Each 109.0000 12 12

AN970-4

Washer

**

Location

Loc Qty

Loc Code

ST344

109

115936

11

116900

1

117795

97

MS21042L5 Purchased No

250 Each 2,022.000 4 4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

2022

116105

5

116548

43

117611

50

118179

424

119109

1500

January-10-12 9:48:52 AM

Shop Packet Print

Page 4

| W/O: 78463 | | WORK ORDER CHANGES | | | | | | |
|------------|------|--|----|---------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | 150 | ANS-32A M118628 (u) ANS-30A M117514 (x) M118206 | SP | 11/1/25 | | | S 12/1/25 | |
| | | PAGE #3 missing or w/o | | | | | | |

Part No: D206-667-107BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

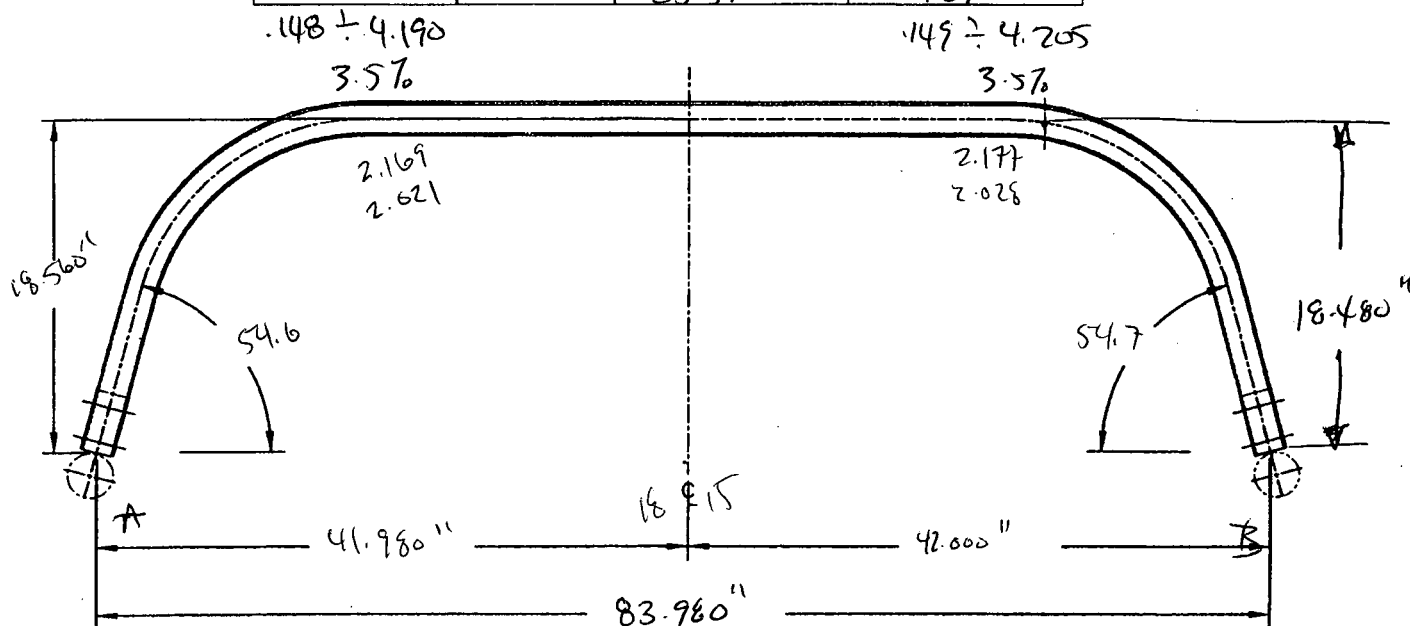
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 78463 |
| Description: 206L mid Rod cross tube. | Part Number: | D206-667-807 |
| Inspection Dwg: D206-667-141 Rev: A | | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|--------|---------|
| Height | 18.34" | 18.600" |
| 1/2 Span | 41.79" | 42.05" |
| Angle | 54° | 56° |
| Total Span | 83.59" | 84.09" |



| Comments |
|-------------------------------------|
| Since A = 3.5% crushing @ 18 Passes |
| Since B = 3.5% crushing @ 15 Passes |

| | |
|-----------------|----------|
| QC15 Inspection | <i>S</i> |
| Date | 12/01/11 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| A | | New Issue | | |
| B | 06.09.19 | Reformat; QC level revised | KJ/JM | |
| C | 07.02.06 | Reformat | KJ/JM | |

| Item | Qty -147 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-147 | CROSSTUBE ASSEMBLY (206L MID FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 99.84±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-147" AND BATCH NUMBER ON
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 15.0 lbs (-507 = 12.84)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO 78463 M.C.J.
 12/01/10

DEO ATTACHED

ECU #11-615
 11.07.28

UNDER REVIEW

RELEASED
 2011-05-24
 JN

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | CP | 10.11.23 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.12.23 | | |

| | |
|---|------------------------|
| DART AEROSPACE LTD | |
| HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D206-667-147 | REV. A SHEET 1 OF 4 |
| TITLE CROSSTUBE ASS'Y (206L MID FWD) | SCALE NTS |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

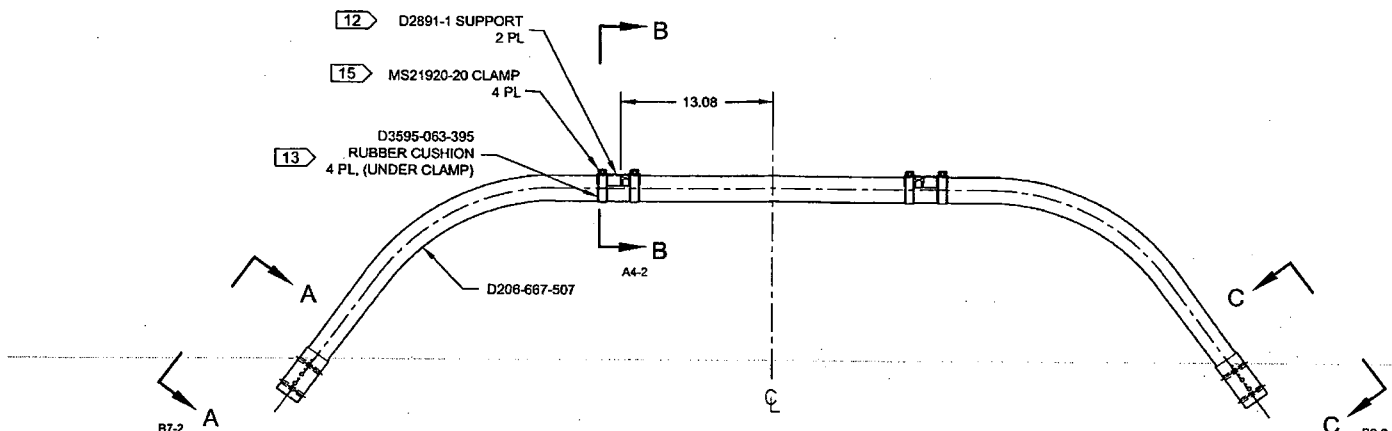
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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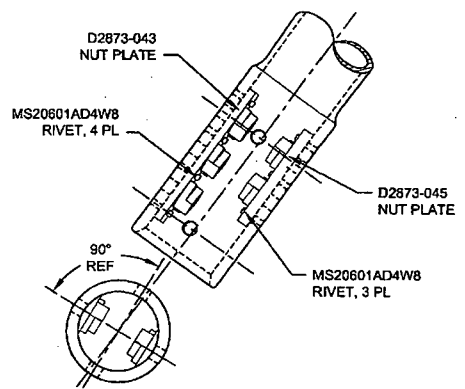
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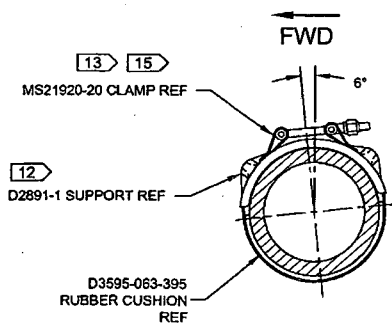
ECW #1.615
1.07.28
UNDER REVIEW
11/06/13

D206-667-147
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

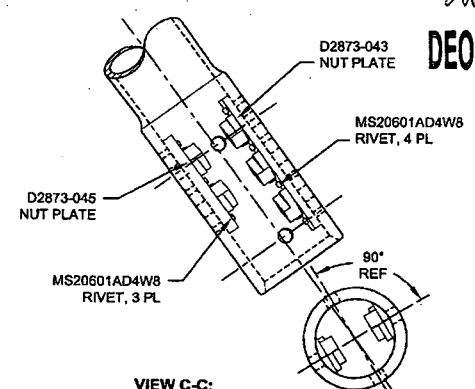
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2011-05-24
DEO ATTACHED



VIEW A-A:
CUFF DETAIL
SCALE 4X



SECTION B-B
SCALE 5X



VIEW C-C:
CUFF DETAIL
SCALE 4X

| | | | |
|--|----------|--|--------------|
| DESIGN | 99 | DART AEROSPACE LTD | |
| DRAWN | 99 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | ED | D206-667-147 | SHEET 2 OF 4 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | HA | CROSSTUBE ASS'Y (206L MID FWD) | NTS |
| DATE | 10.12.23 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

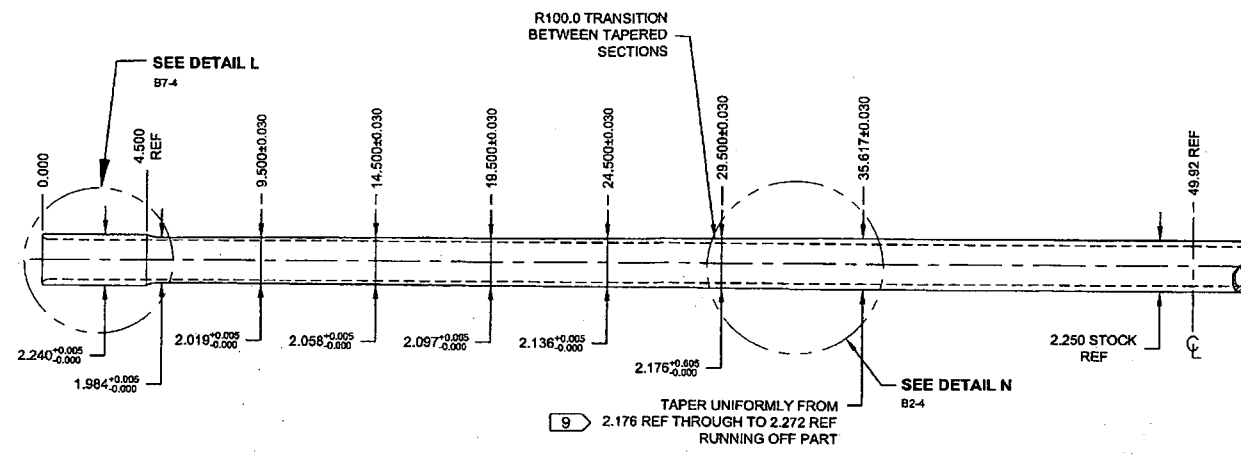
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

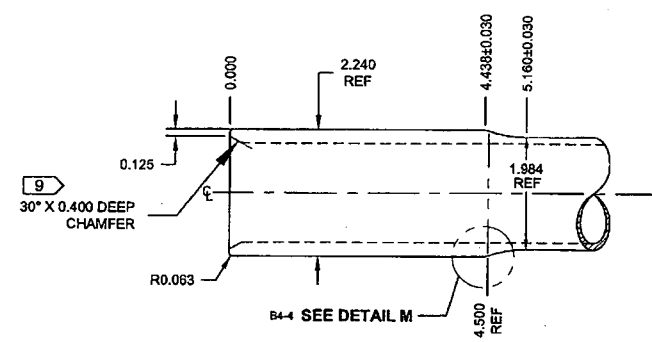
78463

UNDER REVIEW

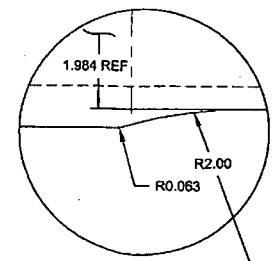
11.06.15
ECO #11-615
11.07.28



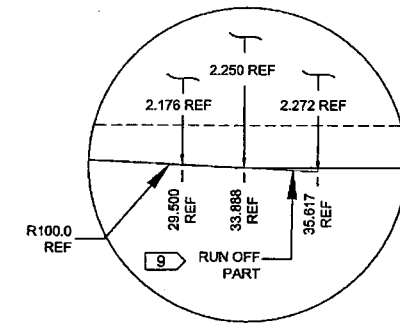
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4
NOT TO SCALE

DEO ATTACHED

RELEASED
2011-05-23

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D206-667-147 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CROSSTUBE ASSY (206L MID FWD) | NTS |
| DATE | 10.12.23 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78463

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|-----------------------------|---|---------------------------|---|-------------------------|--------------------------------|---------------------------|--------------|
| DRAWING NO. D206-667-147 | TITLE CROSSTUBE ASS'Y (206L MID FWD) | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D206-667-147-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 90 | CHECKED ASS | MFG. APPR. [Signature] | APPROVED [Signature] | DE APPR. [Signature] | | | |
| DATE 11.07.15 | DATE 11.07.20 | DATE 11.07.21 | DATE 11/07/21 | DATE 11.07.21 | | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -147 | Part Number | Description |
|------|-------------|-----------------|-------------------------------|
| 9 | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | |
|---|-----|----------------|---|
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 12250

| | | | | | | | |
|------------------|--|-----------------|-------------------------|---------------|--|-----------------------------|----------|
| CLIENT | <u>DAT Aerospace</u> | DATE | <u>JAN 18 2012</u> | PAGE | <u>1</u> | OF | <u>1</u> |
| ATTENTION | <u>CHANTAL</u> | ACUREN JOB NO. | <u>128-12-C0010</u> | TIME | AM <input checked="" type="checkbox"/> | PM <input type="checkbox"/> | |
| ADDRESS | <u>1270 ABERDEEN ST.</u> <u>HAWKES BAY CNT.</u> | PO/NO No. | <u>-</u> | WORK LOCATION | <u>SAME</u> | | |
| PROJECT | <u>F.P.E. on CROSS TUBES.</u> | ACCEPTANCE STD. | <u>ASTM 1417/OSI-08</u> | REV./DATE | <u>2005</u> | | |
| ITEM(S) EXAMINED | <u>(10) UNITS</u> | | | | | | |

| | | | | | | |
|-----------------|--|-----------|-------------------------|------------------------------|----------------|-------------|
| JOB DESCRIPTION | PROCEDURE No. <u>LT-0002</u> | REV./DATE | <u>2008</u> | TECHNIQUE No. <u>LT-1047</u> | REV./DATE | <u>2008</u> |
| PART No. | <u>SFE RESULTS</u> | MATERIAL | <u>ALUMINE ALUMINUM</u> | THICKNESS | <u>VARIOUS</u> | |
| SCOPE | <u>A WET FLOUORESCENT LIQUID PENETRANT INSPECTION</u> <u>CARRIED OUT ON 100% EXTERNAL SURFACE</u> | | | | | |

| | |
|--|---|
| TEST DETAILS | |
| METHOD | <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE |
| FAMILY BRAND | <u>ZYGLC - MAGNAFLUX</u> |
| PENETRANT | <u>2467</u> MINIMUM DWELL TIME <u>45</u> MIN. |
| PENETRANT REMOVER | <u>120</u> MINIMUM DRY TIME <u>>10</u> MIN. |
| DEVELOPER | <u>SK052</u> MINIMUM DWELL TIME <u>10</u> MIN. |
| DEVELOPER TYPE | <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY |
| WATER WASH <input checked="" type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED <input type="checkbox"/> | |
| BLACK LIGHT S/N <u>16459</u> <input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc | |
| LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE | |
| OTHER <u>LABINO</u> | |
| LIGHT METER S/N <u>1098866</u> CAL DUE DATE <u>FEB 2 2012</u> | |

| | |
|---------------------|---|
| TEST SURFACE | |
| SURFACE CONDITION | <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL |
| SURFACE TEMPERATURE | <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F |

| | |
|---|---|
| RESULTS- <input checked="" type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL | <div><p>1 - CROSS TUBE W.O. 78464 ✓</p><p>1 - CROSS TUBE W.O. 78463 ✓</p><p>1 - CROSS TUBE W.O. 78806 ✓</p><p>1 - CROSS TUBE W.O. 78805 ✓</p><p>1 - CROSS TUBE W.O. 78677 ✓</p><p>1 - CROSS TUBE W.O. 78675 ✓</p><p>1 - CROSS TUBE W.O. 78468 ✓</p><p>1 - CROSS TUBE W.O. 78674 ✓</p><p>1 - CROSS TUBE W.O. 78676 ✓</p><p>1 - CROSS TUBE W.O. 78946 ✓</p><p>206 047 20104</p></div> <div><p>512101/19</p><p>← WAS REFOUND IN ONE AREA</p></div> |
|---|---|

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

| | |
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| SIGNATURES | |
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